Work Order ID 52885

October 16, 2009 10:34:27 AM

Item ID: D3570-3 **Accept** **Setup Start**

Revision ID: E **Stop**

Item Name: Bracket

Start Date: 16/10/2009 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 02/11/2009 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** RI **Date:** 09-10-16 **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3570	**Revision Nbr** E								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00					9-11-5		
FLOW CNC Waterjet	1-Cut as per Dwg D3570								
6661 .125	Dwg Rev: E Prog Rev: E ***GRAIN DIRECTIONAS PER DWG*** 2-Deburr if necessary								28
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00					9-11-5		
Quality Control									

Work Order ID 52885

October 16, 2009 10:34:28 AM

Item ID: D3570-3
Revision ID: E
Item Name: Bracket
Start Date: 16/10/2009 **Start Qty:** 20.00
Required Date: 02/11/2009 **Req'd Qty:** 20.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				counter 28	0		
130 Small Fab Small Fab	Small Fab **Memo** 1-Form as per Dwg D3570 Using DT8945 2-Cut excess materialas per Dwg D3570. 3-Drill as per Dwg D3570 Using Dt8946	0.00 0.00				28X			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				28			

=> Sorlu05

M.L 09/11/04

09-11-13

Work Order ID 52885

October 16, 2009 10:34:28 AM

Item ID: D3570-3
Revision ID: E
Item Name: Bracket
Start Date: 16/10/2009 **Start Qty:** 20.00
Required Date: 02/11/2009 **Req'd Qty:** 20.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				X28	0		
160 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112558 **Memo** START TIME: 3:15pm OVEN TEMPERATURE: 320°F FINISH TIME: 3:45pm	0.00 0.00				28	0		
170 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				28			

Work Order ID 52885

October 16, 2009 10:34:28 AM

Item ID: D3570-3
Revision ID: E
Item Name: Bracket
Start Date: 16/10/2009 **Start Qty:** 20.00
Required Date: 02/11/2009 **Req'd Qty:** 20.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:**_____ **Tooling:** _____ **Date:**_____
QC: _____ **Date:**_____ **SPC (Y/N):** _____ **Date:**_____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location:_____	0.00				9/11/19		SP	
Packaging	**Memo**	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00						09/11/18	
QC	**Memo**	0.00							
Quality Control									

MF
29-11-18

Picklist Print

October 16, 2009 10:34:33 AM

Work Order ID: 52885

Parent Item: D3570-3RevE

Parent Item Name: Bracket

Comments:

Start Date: 16/10/2009 **Required Date:** 02/11/2009

Start Qty: 20.00 **Required Qty:** 20.00

Component Item ID / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	105.0952	1.8316	3,		
6061-T6 .125 Sheet											KB 9-11-5	

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	105.0952		
110062	1.85		
111642	19.592		
112476	32		
112567	51.6532		112567

58

DART AEROSPACE LTD	Work Order:	52885
Description: BRACKET	Part Number:	D3570-3
Inspection Dwg: D3570-3 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .209	+.005 -.001	.211	X			
.435	+/- .010	.433	X			
.658	+/- .010	.658	X			
1.841	+/- .010	1.841	X			
2.064	+/- .010	2.066	X			
2.38	+/- .030	2.384	X			
.359	+/- .010	.358	X			
.557	+/- .010	.554	X			
1.943	+/- .010	1.945	X			
2.141	+/- .010	2.141	X			
5.25	+/- .030	5.255	X			
1.00	+/- .030	1.007	X			
.125	+/- .010	.120	X			

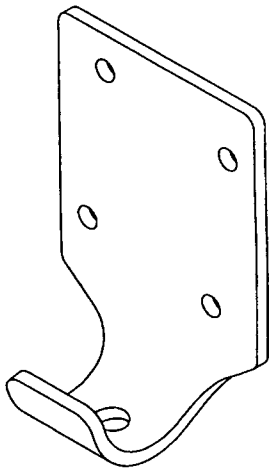
Measured by:	JB
Date:	9-11-4

Audited by:	
Date:	09/11/05

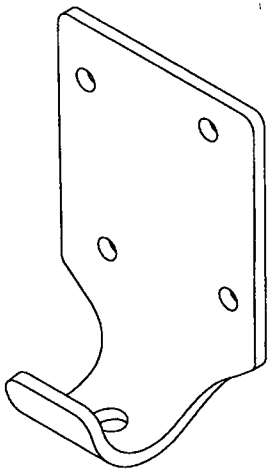
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

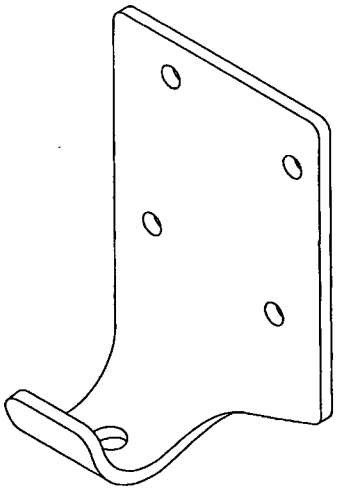
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NO. 52885
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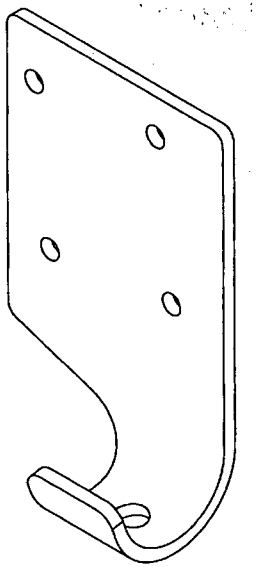
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

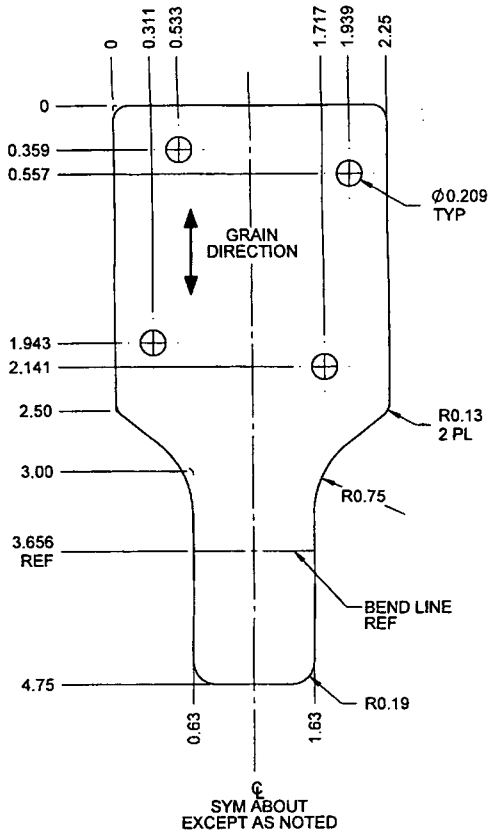
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NOTES:
1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.10 lbs EACH

REV.	DESCRIPTION	BY	DATE
E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07

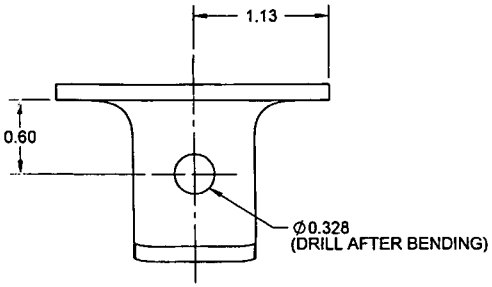
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3570	REV. E
MFG. APPR.			SHEET 1 OF 5
APPROVED		TITLE BRACKET	SCALE NTS
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DATE	09.04.22		

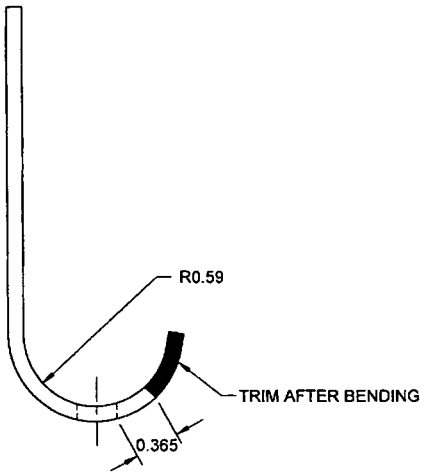
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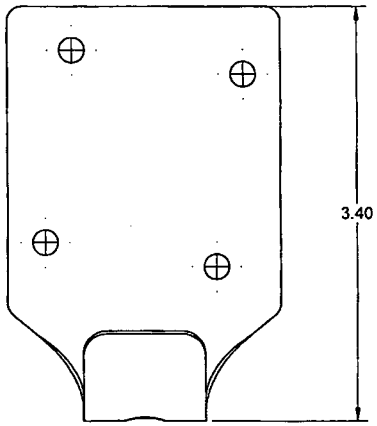


D3570-1F FLAT PATTERN

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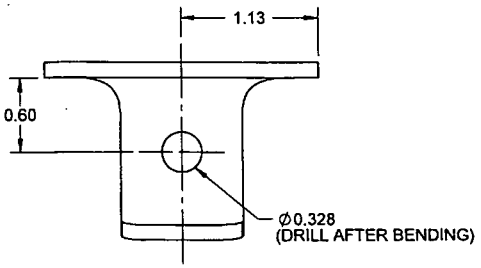


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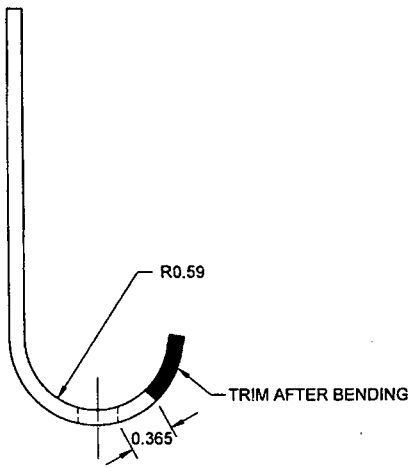
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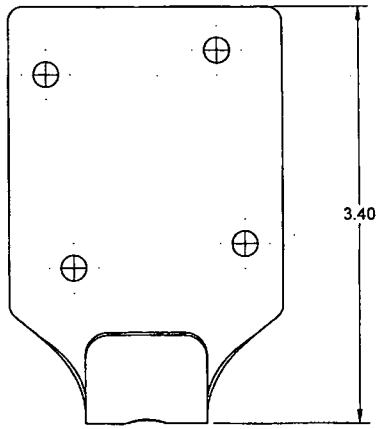
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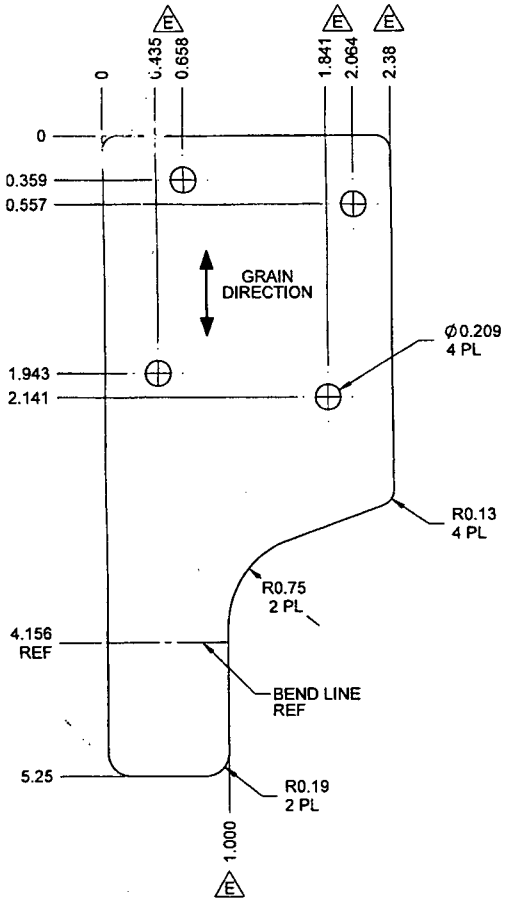


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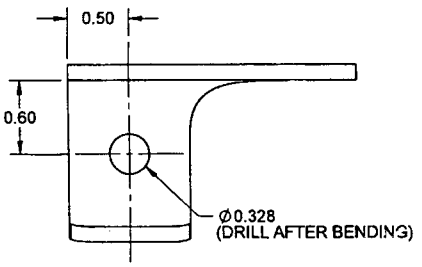
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DE APPR.		BRACKET	NTS
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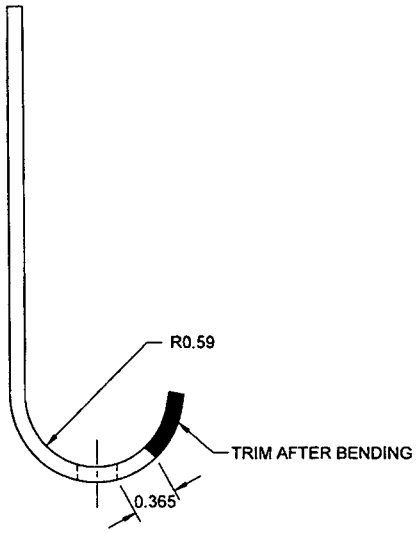
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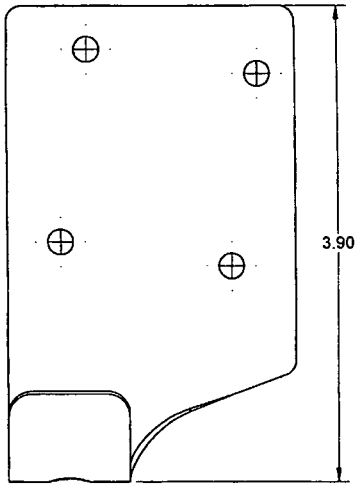


D3570-3F FLAT PATTERN

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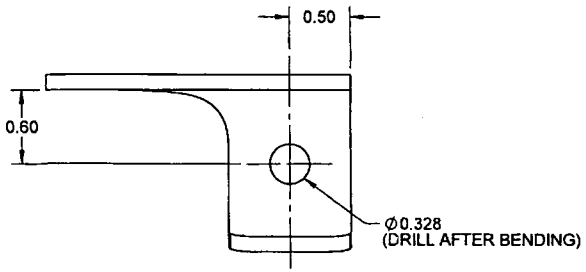


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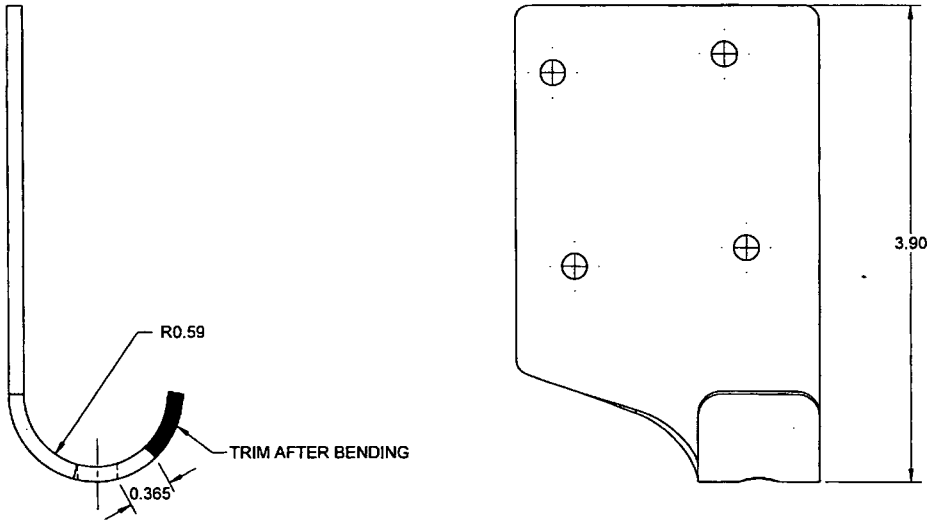
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D3570-4 BRACKET
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